

Date: Monday, 7/9/2007 11:47:31 AM
 User: Kim Johnston

Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT WEB
 Job Number : 33373
 Estimate Number : 10791
 P.O. Number : *N/A* Part Number : D3282041
 This Issue : 7/9/2007 S.O. No. : *N/A* Drawing Number : D3282 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 33224 Material : *N/A*
 Written By : Due Date : 7/20/2007 Qty: 6 Um: Each
 Checked & Approved By : *07.07.09*
 Comment : Est Rev: B 05.09.23 Procedure change KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0: D2792130 EXTRUSION



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2792-130 Extrusion

Identify as D3282-1

*B24030**DP 7-7-12**(8)*

2.0: LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3282.

*DP 7-7-12**(8)*

3.0: HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

*ml 07/07/19**(16)*

4.0: QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ml 07/07/19**(6)*

5.0: QC8 SECOND CHECK



Comment: SECOND CHECK

SA 07.07.19 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:47:31 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 33373

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7-7-20

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PW07072006

8.0

D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

B 52477 (12)

7-7-20

9.0

MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total : 456.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

M100854 (285)

M104291 (57)

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web

A/RN/ALPS-3 M104929

7-7-21

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EN 070723 (46)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

46 DP 7-7-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 21/07/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:47:31 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 33373

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

20070724

Job Completion



20070724

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 33373
Description: Float Web		Part Number: D3282-041
Inspection Dwg: D3282	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.620	✓			
1.500	+/-0.010	1.500	✓			
3.000	+/-0.010	3.000	✓			
6.000	+/-0.010	6.000	✓			
1.250	+/-0.010	1.250	✓			
30.000	+/-0.010	30.000	✓			
1.500	+/-0.010	1.500	✓			
72.01	+/-0.030	72.000	✓			
61.75	+/-0.030	61.750	✓			
57.50	+/-0.030	57.500	✓			
49.19	+/-0.030	49.190	✓			
43.94	+/-0.030	43.930	✓			
39.69	+/-0.030	39.680	✓			
26.68	+/-0.030	26.680	✓			
0.55	+/-0.030	0.550	✓			
1.970	+/-0.010	1.971	✓			
2.38	+/-0.030	2.380	✓			
0.05	+/-0.030	0.055	✓			

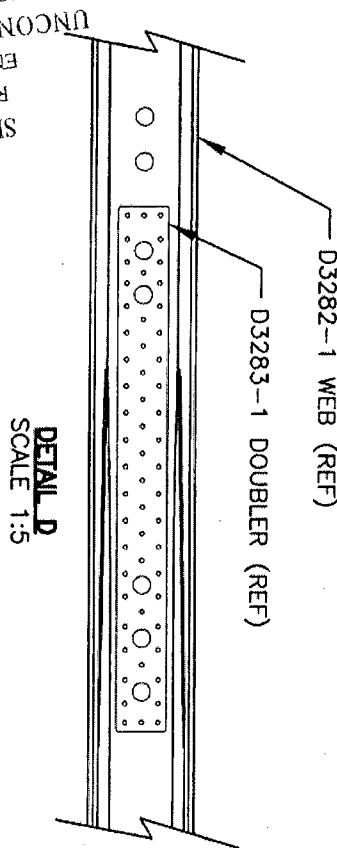
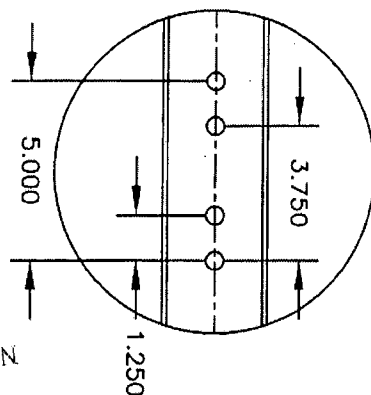
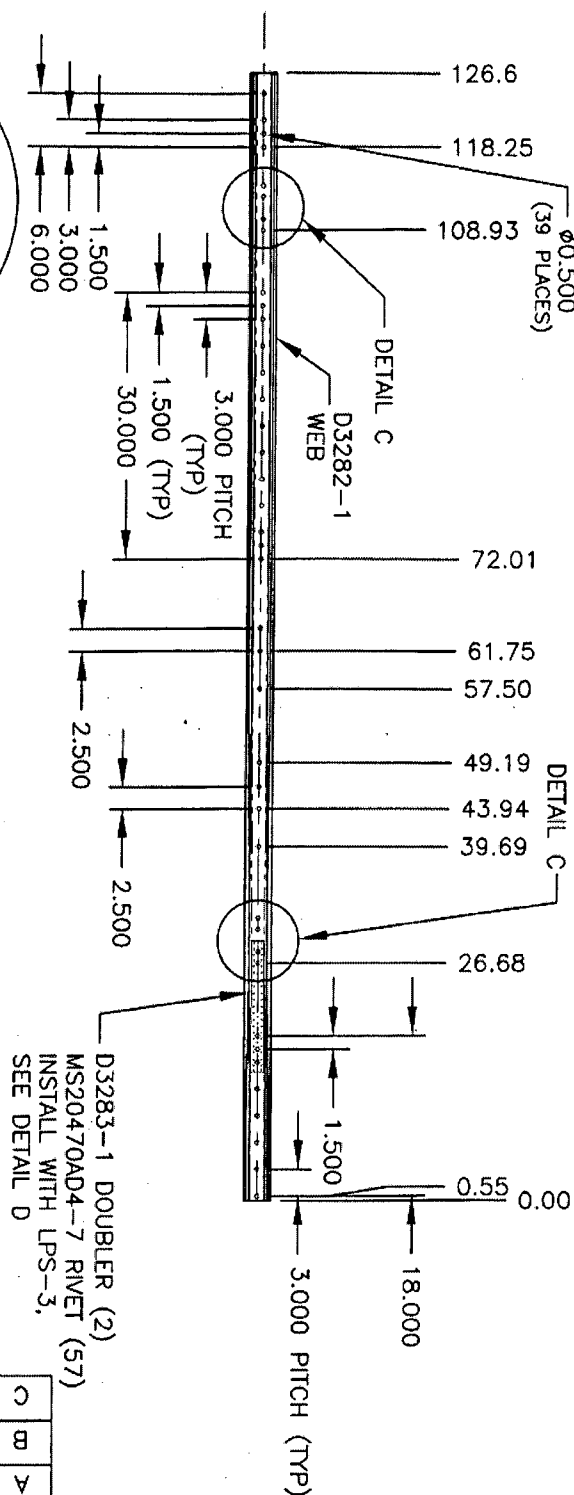
Measured by: JML	Audited by: SA	Prototype Approval:	N/A
Date: 07/07/17	Date: 01.01.19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	SA



DESIGN	CP	CHECKED	APPROVED	DRAWING NO.	REV. C
DRAWN BY	CP			D3282	SHEET 1 OF 2
DATE	05.08.09				
TITLE	FLOAT WEB, 206L/407				
SCALE	1:20				
A	04.05.05 NEW ISSUE				
B	05.03.16 MOVE HOLES, ADD D3390-1 DOUBLERS				
C	05.08.09 REMOVE D3390-1, NOW MACHINED				

RELEASED
05.09.12



UNCONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY
WORK ORDER
NO. 33373
SUBJECT TO AMENDMENT
WITHOUT NOTICE

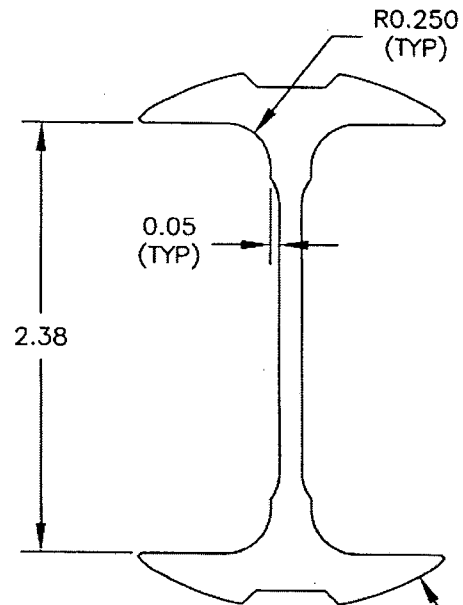
D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
- 3) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

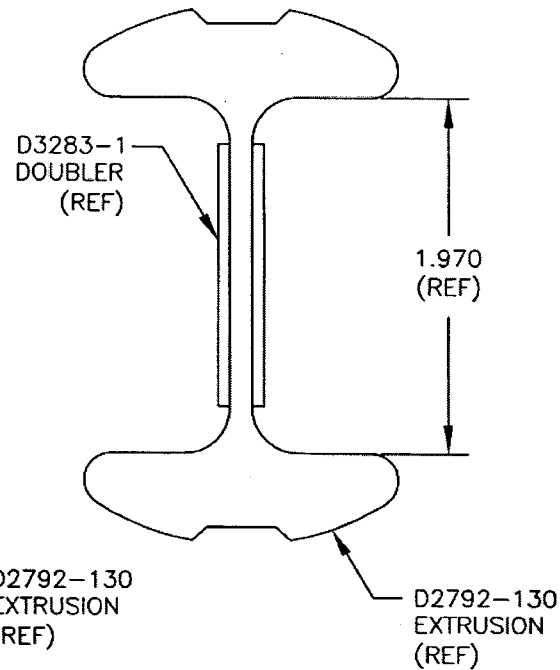


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	TITLE	D3282	REV. C
			FLOAT WEB, 206L/407	SHEET 2 OF 2
				SCALE 1:20

SECTION A-A

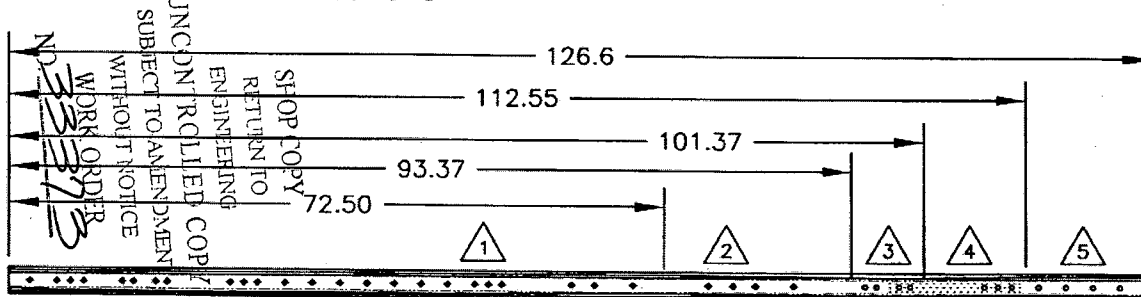


SECTION B-B



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 4 DRILL #30 ($\phi 0.128$ REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED

05.08.12